

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006500**Date Inspected:** 28-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Le and Li Lin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA inspector performed MT of approximately 15% and VT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as Lift 2 East Tower, Lift 2 South Tower, Lift 3 East Tower Skin E Double Plate and OBG 9DE. The weld designations reviewed are as follows:

Bay 11

1. Triangle Diaphragms on 53M, 71M @ corner seam C/D.

2. EDS1-FESA3-2D/D-1, 2, 7, 11 and 14

3. DP-539-001

4. SSD1-TL5B/L-3B

This QA Inspector observed the following work in progress:

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FCAW welding of weld joint 31 located on PCMK WSD1-FASA3-2E/E.

Welder is identified as Mr. Wei Xingli (067499). ZPMC QC is identified as Mr. Li Le.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P5-F.

FCAW welding of weld joint 30 located on PCMK WSD1-FASA3-2E/E.

Welder is identified as Mr. Shi Jiabao (068494). ZPMC QC is identified as Mr. Li Le.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P5-F.

FCAW welding of weld joint 24A located on PCMK WSD1-FASA3-2E/E.

Welder is identified as Mr. Liu Chenfu (069095). ZPMC QC is identified as Mr. Li Le.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P5-F.

FCAW welding of weld joint 35 located on PCMK ESD1-TL7K/L.

Welder is identified as Mr. Zhang Lliang (067036). ZPMC QC is identified as Mr. Li Lin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2a-F.

FCAW welding of weld joint 36 located on PCMK ESD1-TL7K/L.

Welder is identified as Mr. Li Zhaoqian (048810). ZPMC QC is identified as Mr. Li Lin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2a-F.

SAW welding of weld joint 8A located on PCMK WSD1-FBSA3-2A/C.

Welder is identified as Mrs. Yang Meizhen (042195). ZPMC QC is identified as Mr. Xu Le Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-U3c-S-2.

SMAW welding of weld joint 1 A/B located on PCMK WD1-A467-43M-1.

Welder is identified as Mr. Yin Guoqiang (058792). ZPMC QC is identified as Mr. Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-485-SMAW-2G(2F)-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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